

Work Order ID 120134

Wednesday, June 04, 2014 2:56:39 PM

120134

Page 1

Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Deck Plate Fwd
 Start Date: 6/04/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-06-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2364	Rev F								

100 FLOW WATER JET 0.00 ***100*** **DAS 23 9-89 14-06-21**
 Waterjet Memo 0.00 **34 0**
 FLOW CNC Waterjet 1-Cut as per Dwg D2364 Dwg Rev: F Prog Rev: F 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00 ***110*** **DAS 23 9-89 14-06-21**
 QC Memo 0.00 **34 0**
 Quality Control

120 QC8- Inspect parts - second check 0.00 ***120*** **DAS 27 9-89**
 QC Memo 0.00 **EB 74/6/24**
 Quality Control **(34) out**

DQA: ☒ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Page 3

Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate Fwd
Start Date: 6/04/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/04/14 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3 <i>M.P. 78-10</i> Memo START TIME: <i>2:00</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>2:50</i>	0.00 0.00				<i>34.0</i>	<i>14-6-30</i>		<i>DAS 26 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>EB</i> <i>14/07/01</i>		<i>(34)</i>			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location <i>8482</i> Memo	0.00 0.00				<i>34</i>	<i>14-7-1</i>		<i>DAS 26 9-89</i>

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
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Work Order ID 120134***120134***

Page 4

Wednesday, June 04, 2014 2:56:39 PM

Item ID: D2364

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deck Plate Fwd

Start Date: 6/04/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-07-02
MF
14-7-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
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FAULT CATEGORY

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Picklist Print

June-20-14 1:15:12 PM

Page 1

Work Order ID: 120134

120134

Parent Item: D2364

D2364

Parent Item Name: Deck Plate Fwd

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063		Purchased		No		100	sf	189.1339	0.6469	17			DAS
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M2024T3S 063

2024-T3 .063 sheet

**

DAS
23
9.89

14-06-21

Location

Loc Qty

Loc Code

MAT022

189.1339

123701

16.1039

m127866

63.93

m128354

109.1

128354.

DART AEROSPACE LTD		Work Order: 120134
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.624"	-		V	Jkmos
Ø0.171	+0.005/-0.000	0.172"	-		V	
0.354	+/-0.010	0.353"	-		V	
11.242	+/-0.010	11.242"	-		V	Jkmos
3.031	+/-0.010	3.031"	-		V	
1.903	+/-0.010	1.903"	-		V	
1.128	+/-0.010	1.128"	-		V	
0.354	+/-0.010	0.356"	-		V	
1.340	+/-0.005	1.342"	-		V	
2.326	+/-0.010	2.326"	-		V	
3.312	+/-0.010	3.312"	-		V	
4.298	+/-0.010	4.298"	-		V	
5.284	+/-0.010	5.284"	-		V	
6.151	+/-0.010	6.151"	-		V	
6.270	+/-0.010	6.270"	-		V	
0.354	+/-0.010	0.354"	-		V	
3.031	+/-0.010	3.031"	-		V	
Ø0.656	+0.005/-0.000	0.656"	-		V	
5.003	+/-0.010	5.003"	-		V	
4.605	+/-0.010	4.605"	-		V	
1.776	+/-0.010	1.776"	-		V	
0.980	+/-0.010	0.980"	-		V	
4.487	+/-0.010	4.487"	-		V	
7.192	+/-0.010	7.192"	-		V	
7.567	+/-0.010	7.567"	-		V	
7.942	+/-0.010	7.942"	-		V	
Ø0.191	+0.005/-0.000	0.192"	-		V	
Ø0.197	+0.005/-0.000	0.197"	-		V	
11.145	+/-0.010	11.145"	-		V	
12.181	+/-0.010	12.181"	-		V	Jkmos
11.378	+/-0.010	11.378"	-		V	
11.776	+/-0.010	11.776"	-		V	
12.173	+/-0.010	12.173"	-		T	
4.690	+/-0.010	4.690"	-		V	
0.250	+0.005/-0.000	0.250"	-		V	
3.141	+/-0.010	3.141"	-		V	
0.171	+0.005/-0.000	0.171"	-		V	

Measured by: 9-89	Audited by: EB 27	Prototype Approval:	N/A
Date: 14-06-21	Date: 14/6/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

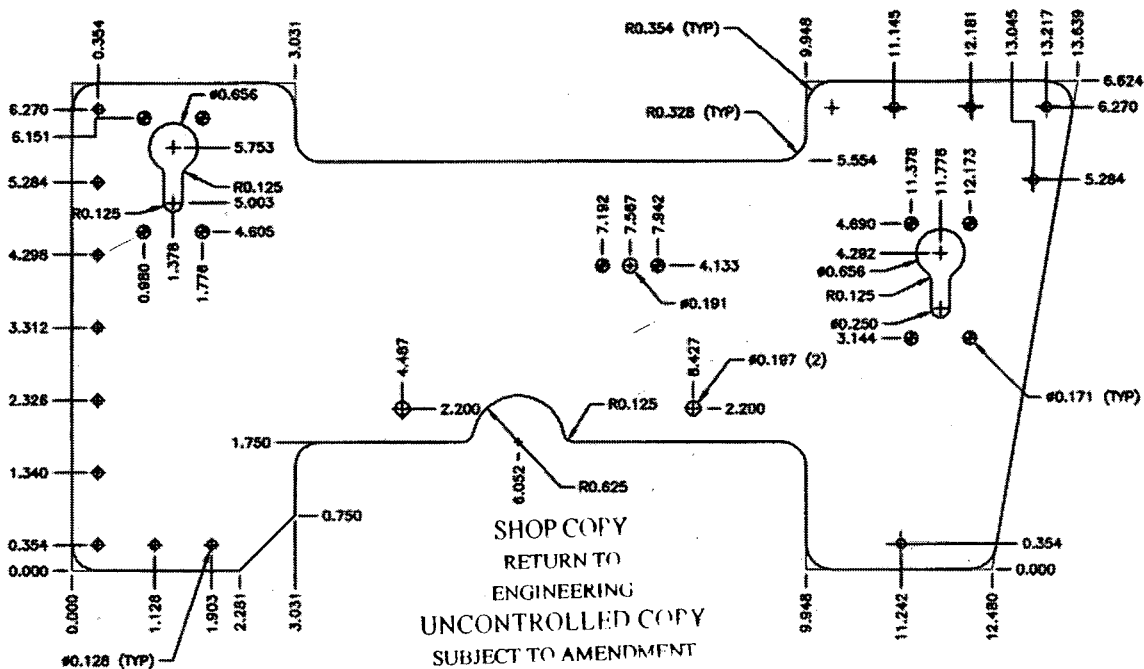
DART



RELEASED
98/06/22 KG

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. F
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2364	SHEET 1 OF 1
DATE 98.06.19		TITLE LITTER DECK PLATE, 350	SCALE 2.5
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEYWAY	
D	95.03.06	0.191 WAS 0.197	
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

- COUNTER SINK HOLES:
- ◆ C'SINK $\emptyset 0.225 \times 100^\circ$ (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)
 - ◆ C'SINK $\emptyset 0.308 \times 100^\circ$



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120134 MLC5
1406-05

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED